












581

Friday, 5/25/2007 8:37:01 AM
Kim Johnston

Process Sheet

Customer	: QU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 32651	Part Number	: D25941
Estimate Number	: 10178	Drawing Number	: D2594 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/25/2007 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 6/15/2007 Qty: 500 Up: 500
Previous Run	: 32080		
Written By	: <u>James 38</u>		
Checked & Approved By	: <u>James 38</u>		
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 est: 836 EC		

Additional Product

Job Number			
Seq. #	Machine Or Operation:	Description:	
1.0	M6061T6R0.625	6061-T6 Round Bar .625"	
			
Comment: Qty: 0.0547 f(s)/Unit Total: 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/5) 1100-3 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch: <u>1104558</u> <u>DSP 07/07/13</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. <u>DSP 07/07/13</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>DSP 07/07/13</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>SC 07-07-13</u> <u>102</u>			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 <u>HJ</u> <u>07-07-13</u> <u>102</u>			

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Seq. #:

Machine Or Operation:

Description:

60

POWDER COATING

POWDER COATING



M 18144



Comment: POWDER COATING

Powder Coat: Gloss White (Ref: 4 3 5 1) per Dart QSI 005 4.3 (only larger dia. section necessary)

BR/M-L 07-07-16 102

70

QC

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/07/16 (102)

80

PACKAGING RESOURCE #1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 16

M-L

07/07/16

(102)

90

QC

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



07-07-17

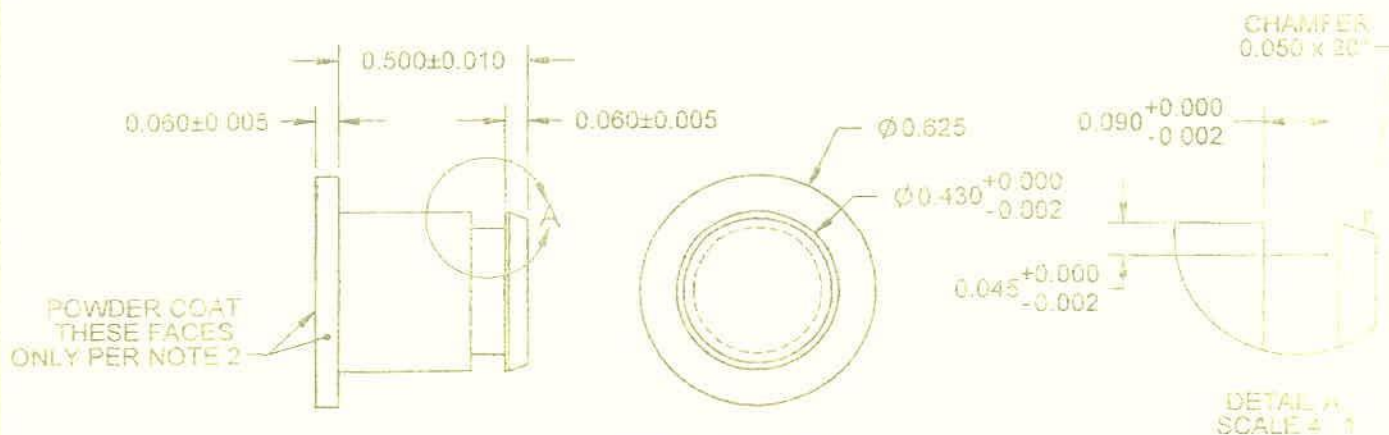
Job Completion



d 07-07-17



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT, ADD MS P/N TO D2594-3 ADD AMS SPECS; ADD TOLERANCE NOTE	



D2594-1 PLUG

D2594-1 PLUG NOTES:

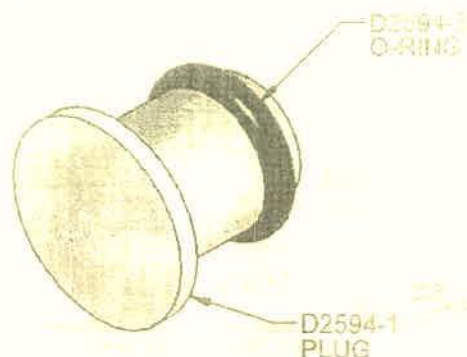
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) CR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-220/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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